<b>Work Ord</b> <i>June-16-14 1:1</i>		21114		*121	1114*						Page 1	
Item ID:	D3573-7		A	Accept	*N900	040	100	<b>)*</b> s	etup Star	<sup>t</sup> *N	S1*	
Revision ID: Item Name:	Adapter								Stop	*N	S2*	
Start Date:	6/16/14	Start Qty: 5.00	*5*		Cust Item I	D;						
Required Date	: 6/16/14	Req'd Qty: 5.00	*5*		Customer:							
Reference:	·						_	R	kun Stai	rt <b>u</b> ri	D4+	
Approvals:	Process Pl	lan: MCJ	Date: 14-06-17	Tooling:	D:	ate:			Sto	~! <i>\</i> J	R1*	
	QC:		_ Date:	<b>SPC</b> (Y/N):	Ds	ate:			510	, *VI	R2*	٠.
Sequence ID/ Work Center I	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Re	evision Nbr					_	-				
D3573	Re	ev A										
100				0.00		_					//11	0
<u>*1</u> 00*		BAND SAW		0.00				5_		- <del></del>	/14/07/	104
Bandsaw Jeaspa Bandsaw		<b>Memo</b> Cut blank	3.500" long	0.00						•		
110				0.00				<b></b>	~/		IA	
*110*		HAAS CNC VERTICA	L MACHINING #1	0.00					Ø		MH	
HAAS CNC vertic	cal machine #1	Memo Machine as	s per Folio FA677 and Dwg D	0.00 03573							14/07/0	5
120		QC2- Inspect parts off r	machine FAI/FAIB	0.00				5	Ø		MH	
*120* QC Quality Control		Мето		0.00					_ <del></del>		- 1401 14/07/	ろ

Quality Control

DQA:		<del></del>	Date:			. WORK ORDER		~	SNEOL		IDDATE					DART
QA Closed:			Date:			WORK ORDER	NON	-((	JNFOI	RIVIANCE		Wo	rk Order up	odate only	$\Box$	AEROSPACE
Work Orde	r:					DISPOSITIO	N				AGAINST	DEP	ARTMENT	/PROCESS		
Part N	•					S	vork			Skid-tube Machining	Crosstube Small Fab			Water Jet d. Eng. Coor.		Engineering Quality Quality
NCR N	o.					Use- Suspected Unappro				noforming Large Fab	Finishing Composite	-	Kec/Stor	re/Packaging Supplier		Other
Root		ï.			Desc	ription of work order	update		nitial	A	ction		Sign &	•		
Cause		Date	Step	Qty		or non-conformance		Ch	ief Eng	Des	cription		Date	Verification		QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													•			
					<del>*</del>			FAI	JLT CAT	EGORY		•		<u>.</u> .		
Landin	g G	iear				General										,
		Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspection Marks/Ch Turning Se	ik/Ripple, t n Strip in atter	/Wave		Bend BOM/Route Broken/Damage/Def Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish	ect		Grain Hardwa Inspecti Instruct Misalig Mislabe Misreac Off-set	on Incomplete/lions Incomplete, ned/off center	/Unclear	F	Outside Dimo Over/Under Part Incorrect Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ci ssing /rong	S T V V	ressure/Forced et-up emperature/Cure Veld Vrong Stock Pulled
	$\overline{}$	Wave/Twi		e	<u> </u>	Fit/Function		_		Sequence		-		-		

Work Ord June-16-14 1:		21114		*12	1114*		
Item ID: Revision ID:	D3573-7			Accept	*N900040100*	Setup	
Item Name:	Adapter						St
Start Date:	6/16/14	Start Qty: 5.00	*5*		Cust Item ID:		
Required Dat	<b>e:</b> 6/16/14	<b>Req'd Qty:</b> 5.00	*5*		Customer:		
Reference:						_	C.
Approvals:	Process Pl	lan:	Date:	Tooling:	Date:	Run	St
 ;	QC:		_ Date:	_ SPC (Y/N):	Date:		S

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00						DAS
*130*					5			25
QC	Memo	0.00		•				3-03

Chemical Conversion Coat per QSI005 4.1 0.00

\*140\*
HandFinish 0.00 Memo Hand Finishing

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00

\*150\*

Quality Control

140

150

Powdercoat

Powder Coating

5 \$ 1479.

Page 2

\*NS2\*

DQA:		_ Date:											TOAPT
		<b>5</b> .			WORK ORDER	RINON	-CO	NFO	RMANCE / U				AEROSPACE
QA Closed:		Date:			<del>-</del> -						Work Order u	pdate only	
Work Order:					DISPOSITIO	N				AGAINST	DEPARTMENT	/PROCESS	
					Rev	vork	1 I		Skid-tube	Crosstube		Water Jet	Engineering
Part No						cnap	11	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-	1 -	1 1		noforming	Finishing	<del></del>	re/Packaging	
NCR No					Suspected Unappro	1	1		Large Fab	Composite		Supplier	<del></del>
						1 —	1		· 🗀			•••	
Root				Desc	ription of work order	update	Ir	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	:	Chi	ef Eng	Desci	ription	Date	Verificatio	n QC Inspector
Design										-			
Doc/Data	_					1							
Equip/Tooling	_					1							
Handling/Pre:						1							
Material	4					I							
Operator	╡ .					l					İ		
Offset/Setup	4	:				1							
Process	_					l							
Supplier	4					1							
Training	4										·		
Transport	4												
Unapproved	ļ	<u> </u>				<u> </u>	<u> </u>						
						<u> </u>	FAU	ILT CAT	EGORY				
Landing	_				General		Ш.	- 1: /p		г	¬		<b>□</b>
<u> </u>	Bending	-+ C		-	Bend BOM/Bassas		-		rogram	-	Outside Dim		Pressure/Forced
<u> </u>	-	ot Concer	itric	-	BOM/Route		-	Grain		-	Over/Under		Set-up
-	Crime	nk/Binnla	Maria	$\vdash$	Broken/Damage/Def	ect	-	Hardwa		1:£:l	Part Incorred		Temperature/Cure
	Cuffs	nk/Ripple	wave	-	Burrs		-		on Incomplete/Ur	-	Part Lost/Mi	issing	Weld
-	Crushing			-	Countarink		-		ions Incomplete/l	Inclear	Part Moved		Wrong Stock Pulled
<u> </u>	Heat Trea			$\vdash$	Countersink Cut Too Short		$\blacksquare$	iviisaiig Mislabe	ned/off center	}	Positioned V Power Loss/	_	Othor
<u> </u>	Inspectio		Tubo	$\vdash$	Drawing		-	Misreac Misreac		L		ourge	Other
-	Marks/Cl		IUDE		Drill Holes		$\boldsymbol{\vdash}$	off-set	•		•	· · · · · · · · · · · · · · · · · · ·	
<del>                                   </del>		Sequence			Finish		-		Calibration		<del></del>		· · · · · · · · · · · · · · · · · · ·
		vist in Tub	e		Fit/Function		-		Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

# \*121114\*

Page 3

June-16-14 1:18:47 PM Item ID: D3573-7 Accept \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Adapter **Start Date:** 6/16/14 Start Qty: 5.00 **Cust Item ID:** Required Date: 6/16/14 Rea'd Oty: 5.00 **Customer:** Reference: Run Start **Approvals:** Process Plan: Date: **Tooling:** Date: Stop QC: SPC (Y/N): Date: Date: Tool # Plan Reject Sequence ID/ Operation Set Up/ Tool ID Accept Reject Insp. DAS Code Qty **Qty** Number Stamp **Work Center ID Description Run Hours** 27 QC3- Inspect Part Finish 0.00 160 9-89 14/07/09 \*160\* 0.00 Memo Quality Control Identify as per dwg & Stock Location: 6 A 0.00 DAS 170 JUL 0 9 2014 28 \*170\* Packaging 0.00 Memo Packaging MF 7-09 180 QC21- Final Inspection - Work Order Release 0.00 \*120\* 0.00 OC Memo **Quality Control** 

DQA:			Date:											DART
QA Closed:			Date:			WORK ORDER	RNON	-CC	ONFOI	RMANCE / U		ork Order uj	odate only	AEROSPACE
Work Ord	er.			<del></del>		DISPOSITIO	N				AGAINST DE	-	<del></del>	<u> </u>
Part I	-		·-			S	vork			Skid-tube Machining	Crosstube Small Fab	-1	Water Jet d. Eng. Coor.	Engineering Quality
NCR I	No					Use-G Suspected Unappro	· -		Thern	noforming	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root		-			Desc	ription of work order (		li	nitial	Act	ion	Sign &		
Cause	$\dashv$	Date	Step	Qty		or non-conformance	<u>.                                    </u>	Chi	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved										÷				
								FAL	JLT CAT	EGORY	-		-	
Landi						General						7		7
		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch	sk/Ripple, t n Strip in	/Wave		Bend BOM/Route Broken/Damage/Def Burrs Contamination Countersink Cut Too Short Drawing Drill Holes	ect		Grain Hardwa Inspecti Instruct	on Incomplete/Ur ions Incomplete/U ned/off center iled	· · · · · · · · · · · · · · · · · · ·	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	$\vdash$	Turning So Wave/Tw		e	-	Finish Fit/Function		$\vdash$		Calibration Sequence				-

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

June-16-14 1:18:46 PM

Work Order ID: 121114

\*121114\*

Parent Item:

D3573-7

\*D3573-7\*

Parent Item Name: Adapter

**Start Date:** 6/16/14

Required Date: 6/16/14

Start Qty: 5.00

Required Qty: 5.00

**Comments:** 

IPP Rev:A New Issue 07-01-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.50		Purchased	No		100	f	25.9400	0.292	1.536842	2		

M128247

# \*M6061T6B0 500X02 500\*

6061-T6 Bar .500 x 2.50

Loc Code Location Loc Oty MAT001 25.94 124443 2 3.94 M126351

20

\*\*

DQA:		_ Date:											TOART
QA Closed:		Date:			WORK ORDER	NON	-CC	NFO	RMANCE / U		/ork Order uj	adata only	AEROSPACE
QA Closed.	<del></del>	Date.								V	rork Order up	date only	<u> </u>
Work Order	·:			:	DISPOSITIO	N				AGAINST D	EPARTMENT	/PROCESS	
				<del></del>	Rev	verk	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part No	o			:	S	стар	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-	as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No	D			<del></del>	Suspected Unappro	yed 🗌	]		Large Fab	Composite		Supplier	
Root	· · · · · · · · · · · · · · · · · · ·	ï		Desc	ription of work order	update	<u> </u> 	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	•	1	ief Eng		ription	Date	Verification	QC Inspector
Design						1							
Doc/Data													
Equip/Tooling					•	1							
Handling/Pre	_					İ							
Material	_					l							
Operator													
Offset/Setup						İ							
Process													
Supplier						1							
Training	_												
Transport	_				İ								
Unapproved							<u> </u>		<u> </u>				
			<del></del>				FAL	JLT CAT	TEGORY				
Landing	_			_	General		_			,	7	<del></del>	
<u> </u>	Bending				Bend		-	-	rogram		Outside Dim	_	Pressure/Forced
L	_	ot Concer	ntric	<u> </u>	BOM/Route		$\vdash$	Grain			Over/Under	<u> </u>	Set-up
,	Cracks				Broken/Damage/Def	ect	-	Hardwa		<u> </u>	Part Incorred	<b>)</b> —	Temperature/Cure
<u> </u>	_	nk/Ripple	/Wave	_	Burrs		-	-	ion Incomplete/Ur	·	Part Lost/Mi	ssing	Weld
<u> </u>	Cuffs			<u> </u>	Contamination		-		ions Incomplete/l	Jnclear	Part Moved	L	Wrong Stock Pulled
	Crushing				Countersink		-	-	ned/off center	<u> </u>	Positioned V	Vrong	_
_	Heat Tre				Cut Too Short		-	Mislabe		L	Power Loss/	Surge	Other
<u> </u>	<b>—</b>   '	n Strip in	Tube	<u> </u>	Drawing		-	Misread					
	Marks/Cl				Drill Holes		$\vdash$	Off-set					
		Sequence		<u> </u>	Finish		$\vdash$		Calibration				
	IWave/Tv	vist in Tub	e e	ı	Fit/Function		1 1	Out of 9	Seauence				

DART AEROSPACE LTD	Work Order:	121114
Description: Adapter	Part Number:	D3573-7
Inspection Dwg: D3573 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype
---------------------------

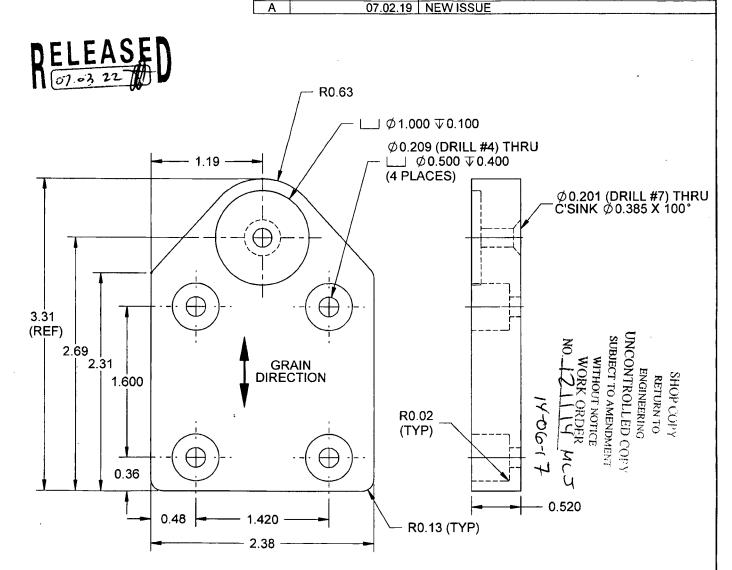
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.32	+/-0.030	3.12	<b>✓</b>		174-04	Caliper
2.75	+/-0.030	1-781	1		ĺ	1
0.36	+/-0.030	.355	<b>S</b>			
1.600	+/-0.010	1-600	<b>✓</b>			
0.48	+/-0.030	. 475	✓ <b></b>			
2.38	+/-0.030	2.375	- /			
1.420	+/-0.010	1-470	/			
1.813	+/-0.010	1.813	6			
Ø0.209	+0.005/-0.001	-710	1			
Ø0.201	+0.005/-0.001	- Jo J	/			
Ø0.90 x 0.100	+/-0.010	488 x 100	<b>/</b>			
Ø0.500 x 0.310	+/-0.010	.498 × 310	✓	-		
0.390	+/-0.010	.391	/			
Ø0.385 x 100°	+/-0.010 x 0.5°	- 385 x 10E	~			
R0.63	+/-0.030	. 63	~		radsvasc	
R0.13	+/-0.030	-13	1		1	ì
R0.02	+/-0.030	.σ2	/			

	<u>Das</u>		
Measured by: ⋈⋈	Audited by: 25	Prototype Approval:	N/A
Date: 14/07/05	Date:	Date:	N/A
Date. 14/0//05	Date. M-4-4	Date.	

Rev	Date	Change	Revised by	Approved/
Α	10.04.01	New Issue	KJ of	







**D3573-1 ADAPTER** 

NOTES:

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

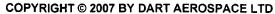
(REF DART SPEC M6061T6B)

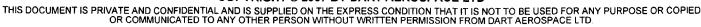
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

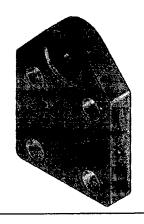
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



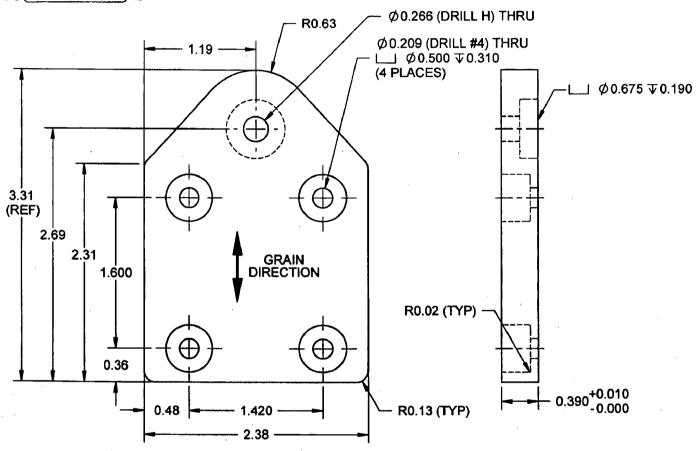






-	DESIGN	DRAWN BY	DART AEROSPACE LTD  HAWKESBURY, ONTARIO, CANADA		
	CHECKED	APPROVED	DRAWING NO.	REV. A	
	OH	- All	D3573	SHEET 2 OF 4	
	07.02.19		ADAPTER	SCALE	
				1:1	





## D3573-3 ADAPTER

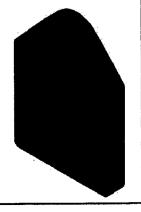
NOTES:
1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

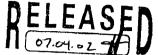
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

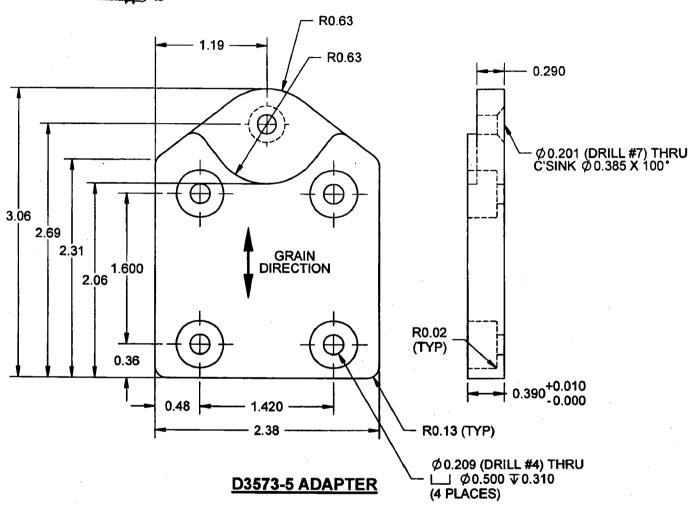


#### **COPYRIGHT © 2007 BY DART AEROSPACE LTD**



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO.	REV. A SHEET 3 OF 4
DATE 07.02.19		ADAPTER	SCALE 1:1





1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

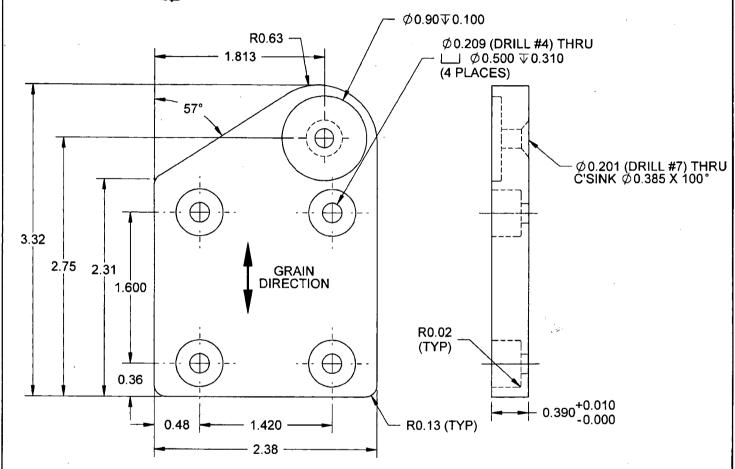


THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





DESIGN	DRAWN BY	DART AEROSI HAWKESBURY, ONTA	
CHECKED  PH	APPROVED	D3573	REV. A SHEET 4 OF 4
07.02.19		TITLE ADAPTER	SCALE 1:1



### **D3573-7 ADAPTER (SHOWN)** D3573-8 ADAPTER (OPPOSITE)

NOTES:

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

